

# Work Order ID 69633

Thursday, May 12, 2011 3:31:04 PM



Page 1

Item ID: D3372-7

Accept



Setup Start



Revision ID:

Item Name: Slider Body

Stop



Start Date: 5/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00

Customer:

ASAP

Reference:

Approvals: Process Plan: *MUP*

Date: 11-05-18 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3372	Rev B

100	BAND SAW	0.00							
	Bandsaw								
Jcaspa Bandsaw	Memo	0.00							
	Cut blank: 1.500" x 1.250" x 4.435" long								

*and 11/05/18*

*4 0*

110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo	0.00							
	Machine D3372-7 as per Folio FA495 and Dwg D3372 Identify as D3372-7 Deburr								

*B.A. 11/05/19*

*4 0*

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

*B.A. 11/05/19*

*4 0*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69633**

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Page 2

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Start Date: 5/13/2011 Start Qty: 4.00

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml 11/05/19

4

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

0

ml 11/05/19

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4x 0 ml 11/05/20

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# Work Order ID 69633

Thursday, May 12, 2011 3:31:04 PM



Page 3

Item ID:	D3372-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Slider Body					
Start Date:	5/13/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	5/20/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00		11/05/25		4			
Small Fab	Fabricate D3372-9 using AN6-36A bolt. <input type="checkbox"/> Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.								
170  QC	QC5- Inspect part completeness to step on W/O	0.00		8 11/05/26		(X4)			
QC	Memo	0.00							
Quality Control									
180  Powdercoat	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
Powder Coating	Memo	0.00							
	START TIME: 7:30								
	FINISH TIME: 8:15								
	DOVEN TEMPERATURE:								

M102341

4X ~~8~~ m-11/05/20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 69633

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Page 4

Item ID: D3372-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Slider Body

Start Date: 5/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				4	0	11/05/20	
200 	Identify as per dwg & Stock Location: <u>St</u>	0.00							
Packaging Packaging	Memo	0.00							8/5 11/05/26
210 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/5/30

11/5/30  
ME  
11-05-26

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

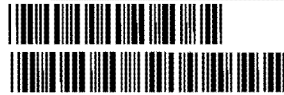
Thursday, May 12, 2011 3:30:58 PM

Page 1

Work Order ID: 69633

Parent Item: D3372-7

Parent Item Name: Slider Body



Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A05.01.18 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-36A  Bolt		Purchased	No			110	Each	81.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST343		81							
				117313		1							
				117441		80							
M6061T6B1.500X01.25 0		Purchased	No			160	f	12.9418	0.3833	1.613895			
6061-T6 Bar 1.50 x 1.25													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT004		12.9418							
				107461		0.9							
				110936		12.0418							

So 11/05/24

4

1.6129 sub 11/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 69633
<b>Description:</b> Slider Body		<b>Part Number:</b> D3372-7
<b>Inspection Dwg:</b> D3372	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.005	0.746	✓		Vern	GA-01
0.313	+/-0.005	0.313	✓		"	"
2.108	+/-0.010	2.108	✓		H-6	31006
1.50	+/-0.030	1.492	✓		Vern	GA-01
0.63	+/-0.030	0.632	✓		"	"
4.31	+/-0.030	4.314	✓		"	"
1.19	+/-0.030	1.186	✓		"	"
0.613	+/-0.010	0.612	✓		"	"
2.938	+/-0.010	2.938	✓		"	"
1.375	+/-0.010	1.376	✓		"	"
0.200	+/-0.010	0.205	✓		"	"
Ø0.323	+0.005/-0.000	Ø0.324	✓		"	"
0.500	+/-0.010	0.500	✓		D-6	GA-08
0.881	+/-0.010	0.881	✓		"	"

<b>Measured by:</b> H.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> N/A
<b>Date:</b> 11/05/19	<b>Date:</b> 11/05/19	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	09.05.04	Dimensions revised	KJ/DD	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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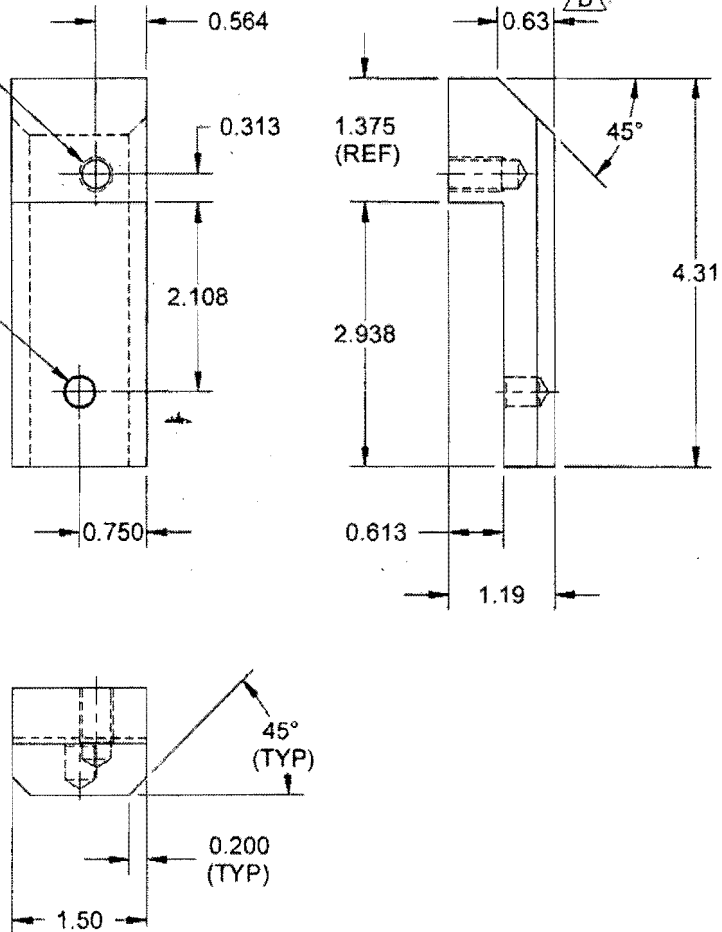
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 7 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

DRILL  $\varnothing 0.332$   
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL  $\varnothing 0.323$   
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

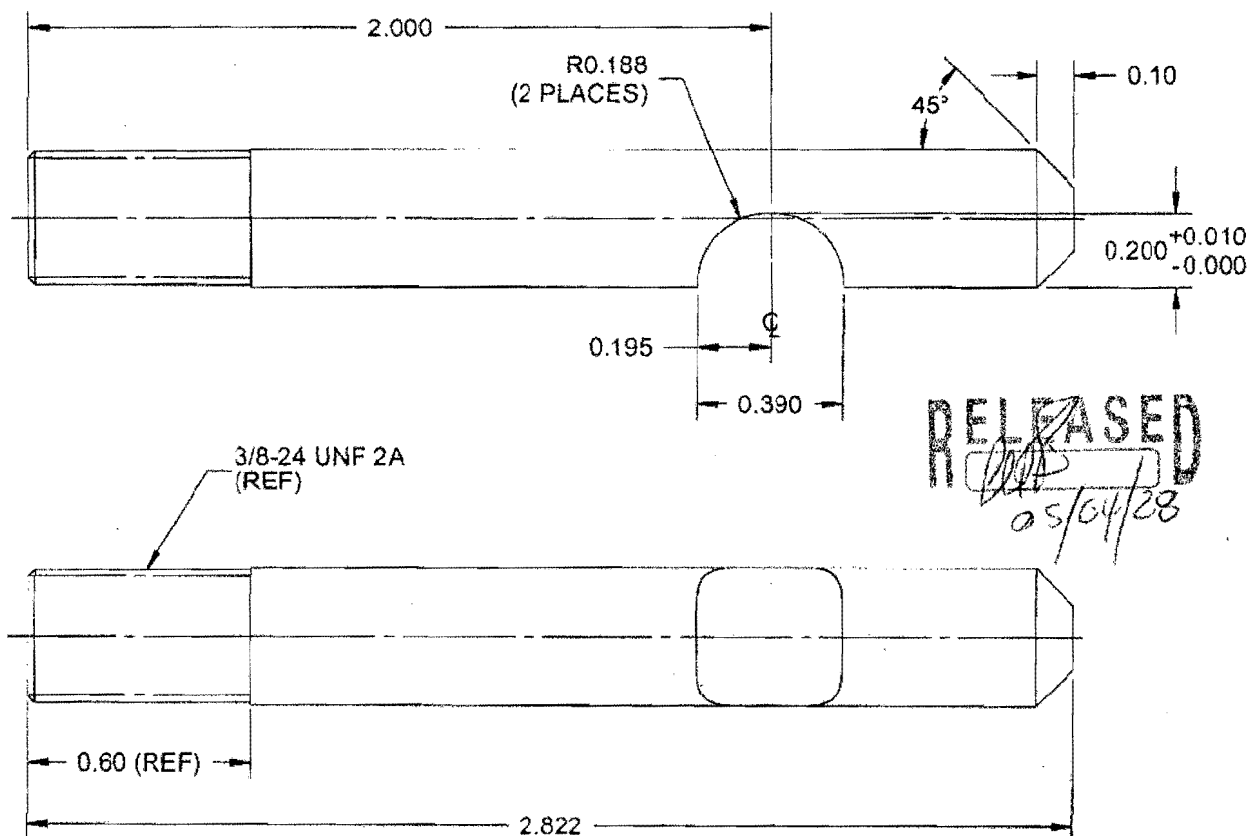
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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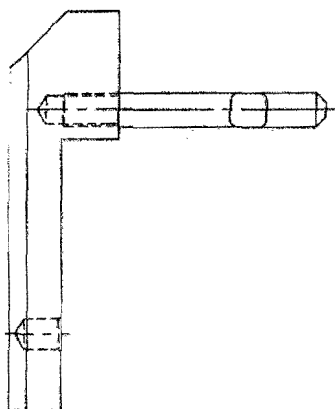
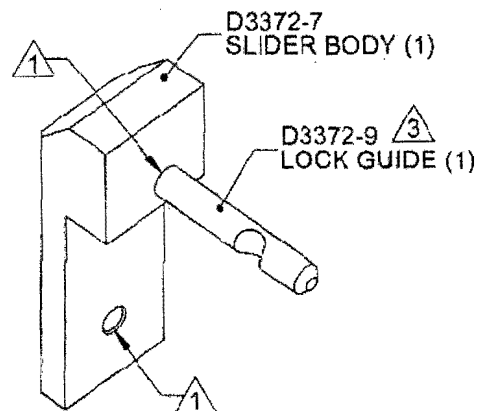
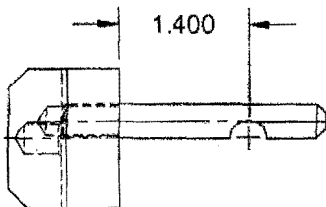






DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED  
*[Signature]*  
05/04/28



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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